

20-8324



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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D3165-1**Job Sheet 207285****Part No:** D3165-1**Job Qty:** 4 pcs**Part Name:** Support Arm**Part Weight:** 0 lbs**Status:** New**Priority:** Medium**Job Created:** 2/24/20**Job Tracking No:****Due Date:** 3/9/20**Created By:** Marie Lajeunesse**Type:** SOLD**Description:****Note:** DWG REV A IPP A 02.09.18 New issue KJ IPP Rev:B Moved Engraving to Haas step 08-09-24 Verified By:EC**Ship Via:****Bill of Materials****Job Routing**

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Bandsaw - 1	4 pcs	3/9/20	3/9/20	0.00	0.10	Bandsaw - 1	52 20/03/01	
110	HAAS 4 Axis - B4B	4 pcs	3/9/20	3/9/20	1.00	6.25	HAAS - 1 - B4B	52 20/03/01	
							HAAS - 2 - B4B	9-89	
							HAAS - 3 - B4B		
							HAAS - 4 - B4B		
120	QC 2	4 pcs	3/9/20	3/9/20	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52	52 20/03/01	
							QC 2 - 57	9-89	
							QC 2 - 62		

**Container No:** S259593**Part:** D3165-1**Job No:** 207285**Serial No/Batch:** S259593**Revision:****Inspector:****Exp Date:****Instructions:** Various STC's

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Date: 03/01/20

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				QC 2 - 63					
				QC 2 - 8					
				QC 2 - 66					
				QC 2 - 64					
				QC 2 - 65					
				QC 2 - 5					
				QC 2 - 71					
				QC 2 - 73					
				QC 2 - 69					
				QC 2 - 76					
				QC 8 - 12					
				QC 8 - 14					
				QC 8 - 17					
130 QC 8	4 pcs	3/9/20	0.00 0.00	QC 8 - 20					
				QC 8 - 25					
				QC 8 - 3					
				QC 8 - 32					
				QC 8 - 33					
				QC 8 - 35					
				QC 8 - 39					
				QC 8 - 4					
				QC 8 - 44					
				QC 8 - 45					
				QC 8 - 49					
				QC 8 - 58					
				QC 8 - 8					
				QC 8 - 9					
				QC 8 - 68					
				QC 8 - 67					
				QC 8 - 1 (A)					
				QC 8 - 47					
				QC 8 - 40					
				QC 8 - 52					
				QC 8 - 23					
				QC 8 - 57					
				QC 8 - 76					
				QC 8 - 61					
				140 Handfinish - 1-1 Chemical- B4B	4 pcs	3/9/20	0.00 0.67	Handfinish - 1 - 1 - B4B	
								Handfinish - 1 - 2 - B4B	
								Handfinish - 1 - 3 - B4B	
								Handfinish - 1 - 4 - B4B	
								Handfinish - 1 - 5 - B4B	
								Handfinish - 1 - 6 - B4B	
								Handfinish - 1 - 7 - B4B	
								Handfinish - 1 - 8 - B4B	
								Handfinish - 1 - 9 - B4B	
Handfinish - 1 - 10 - B4B									
Handfinish - 1 - 11 - B4B									
Handfinish - 1 - 12 - B4B									
Handfinish - 1 - 13 - B4B									
Handfinish - 1 - 14 - B4B									
Handfinish - 1 - 15 - B4B									
Handfinish - 1 - 16 - B4B									
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MAR 03/01

MAR 02 2020

					Handfinish - 1 - 17 - B4B	
					Handfinish - 1 - 18 - B4B	
					Handfinish - 1 - 19 - B4B	
					Handfinish - 1 - 20 - B4B	
					Handfinish - 1 - 21 - B4B	
					Handfinish - 1 - 22 - B4B	
150 Powdercoat - 1 White GI(A)- B4B	4 pcs	3/9/20	0.00 0.11		Powdercoat - 1 - B4B	RF1320.03-03.
					Powdercoat - 2 - B4B	
					Powdercoat - 3 - B4B	
					Powdercoat - 4 - B4B	
160 QC 3	4 pcs	3/9/20	0.00 0.00		QC 3 - 10	
					QC 3 - 13	
					QC 3 - 15	
					QC 3 - 17	
					QC 3 - 18	
					QC 3 - 2	
					QC 3 - 28	
					QC 3 - 3	
					QC 3 - 30	
					QC 3 - 34	
					QC 3 - 36	
					QC 3 - 41	
					QC 3 - 51	
					QC 3 - 58	
					QC 3 - 59	
					QC 3 - 68	
					QC 3 - 9	
					QC 3 - 40	HAB 03 2020 DAS 40 9-89
					QC 3 - 19	
					QC 3 - 43	
					QC 3 - 24	
					QC 3 - 61	
					QC 3 - 81	
					QC 3 - 82	
170 Packaging 3-1 - Stock - B4B	4 pcs	3/9/20	0.00 0.00		Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	ST356
					Packaging 3 - 5 - B4B	DAS 74 9-89
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	

				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 37 - B4B	
180 QC 21 - SA	4 pcs	3/9/20	0.00 0.00	QC 21 - SA - 21	MAR 05 2020
				QC 21 - SA - 70	
				QC 21 - SA - 53	

Part Op 100 - (Bandsaw) Cut Blank: (17.00" x 5.00") +/- 0.030" x 0.500" thick Grain along 17.000"

Descriptions: 110 - (HAAS CNC Vertical Machine) 1-Machine as per Folio FA277 & Dwg D3165-1 2-Deburr 3-Engrave batch number as per Dwg D3165

120 - QC2- Inspect parts off machine FAI/FAIB

130 - QC8- Inspect parts - second check

140 - HandFinish1 Chemical Conversion Coat per QSI005 4.1

523550 150 - Powdercoat1 (White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum) START TIME: 11:05 OVEN TEMPERATURE: 320° FINISH TIME: 11:35

160 - QC3- Inspect Part Finish

170 - Identify as per dwg & Stock Location:

180 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6B0.500X05.000	6061-T6 Bar .500 X 5.00	5.6800 ft (1.42 ea)	100-Bandsaw - 1	520 5223 9.525

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Bandsaw - 1	M6061T6B0.500X05.000	6	52	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Support Arm	8.314inches ± 0.005	8.319 8.309	8.314	
2	Support Arm	4.433inches ± 0.005	4.438 4.428	4.433	
3	Support Arm	0.625inches ± 0.005	0.630 0.620	0.626	
4	Support Arm	0.250inches + 0.005 - 0.000	0.255 0.250	Diameter 0.250	
5	Support Arm	0.257inches + 0.005 - 0.000	0.262 0.257	Diameter 0.257	
6	Support Arm	0.490inches ± 0.010	0.500 0.480	0.490	
7	Support Arm	0.135inches + 0.020 - 0.000	0.155 0.135	0.145	
8	Support Arm	1.250inches + 0.020 - 0.000	1.270 1.250	1.254	
9	Support Arm	0.100inches ± 0.010	0.110 0.090	0.105	
10	Support Arm	0.125inches ± 0.010	0.135 0.115	Radius 0.125	

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Entered: 1h Date: Aug 19/2020



NCR No. 20-8324

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

Route update only ☐

Job: <u>207285</u> Part No. <u>D3165-1</u>		DISPOSITION Rework ☐ Scrap ☒ Use-as-is ☐		DEPARTMENT/PROCESS Skid-tube ☐ Cross tube ☐ Machining ☒ Small Fab ☐ Large Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Engineering ☐ Prod. Eng. Coord. ☐ Water Jet ☐ Rec/Store/Packaging ☐ Supplier Quality ☐																															
Date: <u>20/03/01</u>		Sequence #: <u>110</u>		QTY Affected: <u>1</u>		MRB (QSI042) DAS 9 3-89 <u>20.8.6</u>																													
Description Work Order Deviation				Disposition																															
Engraving of serial# was programmed with old serial#				Scrap and destroy replace Qty 1																															
								Completed By DAS <u>52</u> <u>20/03/01</u> 9-89																											
								Lead hand / Supervisor <u>Onk</u> <u>20/03/01</u>																											
QC / QA Coordinator DAS 9 9-89 <u>20.8.6</u>																																			
Root Cause Operator ☒ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY <table border="0"> <tr> <td>☐ Pressure/Forced</td> <td>☐ Contamination</td> <td>☐ Power Loss/Surge</td> <td>☐ Positioned Wrong</td> </tr> <tr> <td>☐ Bending</td> <td>☐ Misaligned/off center</td> <td>☐ Folio/Program</td> <td>☐ Outside Tolerance</td> </tr> <tr> <td>☐ Crushing</td> <td>☐ BOM/Route</td> <td>☐ Grain Direction</td> <td>☐ Drawing</td> </tr> <tr> <td>☐ Cracks</td> <td>☐ Broken/Damage/Defect</td> <td>☐ Weld</td> <td>☐ Finish</td> </tr> <tr> <td>☐ Crimp/Kink/Ripple/Wave/Twist</td> <td>☐ Incomplete/Unclear Instructions</td> <td>☐ Wrong Stock Pulled</td> <td>☐ Part Lost/Missing</td> </tr> <tr> <td>☐ Marks/Chatter</td> <td>☐ Drill Holes</td> <td>☐ Out of Sequence</td> <td>☒ Misread</td> </tr> <tr> <td>☐ Mislabeled</td> <td>☐ Fit/Function</td> <td>☐ Off-set/Set-up</td> <td></td> </tr> </table>						☐ Pressure/Forced	☐ Contamination	☐ Power Loss/Surge	☐ Positioned Wrong	☐ Bending	☐ Misaligned/off center	☐ Folio/Program	☐ Outside Tolerance	☐ Crushing	☐ BOM/Route	☐ Grain Direction	☐ Drawing	☐ Cracks	☐ Broken/Damage/Defect	☐ Weld	☐ Finish	☐ Crimp/Kink/Ripple/Wave/Twist	☐ Incomplete/Unclear Instructions	☐ Wrong Stock Pulled	☐ Part Lost/Missing	☐ Marks/Chatter	☐ Drill Holes	☐ Out of Sequence	☒ Misread	☐ Mislabeled	☐ Fit/Function	☐ Off-set/Set-up	
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